

Work Order ID 70620

Monday, June 13, 2011 12:45:55 PM



Page 1

Item ID: D3484-041

Accept



Setup Start



Revision ID:

Item Name: Tail Light Fairing Assembly, LH

Stop



Start Date: 6/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11/06/13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3484	Rev F

100



Purchasing

Memo

0.00

CL 11/06/13 ⑧

Purchasing

Issue P/O: 14274
Make as per Dwg D3484
Material release note is required

110



Packaging

Memo

0.00

P 11/11/14 ⑧

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

115



Large Fab

Memo

0.00

Large Fab

Touch up weld if necessary

11-07-18

2 f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

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Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

x B O BE11/07/18

QC

Quality Control

130



QC6- Inspect dimensions to drawing

0.00

S M71.8

(LS) H

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

0.00

8 W 16 Jt u closed

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

QC3- Inspect Part Finish

0.00

8

6 BL 10-7-19

Quality Control

160



Small Fab

Memo

0.00

Small Fab

1-Install Nut Plates as per Dwg D3484

0.00

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



Powdercoat

Powder Coating

W 118439

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo
START TIME:
OVEN TEMPERATURE:
FINISH TIME:
9:15
0.00
1320°
9:45

8x Ø m / 11/08/15

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Ø Ø m / 11/08/15

200



Packaging

Packaging

Memo

0.00

Identify as per dwg and Stock
Location 205
Identify on inside surface as indicated
TCCA-PDA,DART AEROSPACE LTD
P/N:D412-750-141 B/N:XXXXXX
FOR PRODUCT ELIGIBILITY SEE PDA06-13

11/8/15 8D SP

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

δ wlo8115

+8

44

220



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

n/8/1608

CL1108115

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 12:46:02 PM

Page 1

Work Order ID: 70620



Parent Item: D3484-041



Parent Item Name: Tail Light Fairing Assembly, LH

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-04-11 JLM
IPP Rev:B 08-01-24 chg rivet to CR1122-3-025 DD verf:EC IPP Rev:C
11.03.07 added weld touch up DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3484-041P 		Purchased	No		110	Each	0.0000		1	8		6/17/14	(8)
Tail light Fairing 	MS21069-04	Purchased	No		160	Each	82.0000		2	16		6/18/10	
ANCHOR NUT 				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST302			82						
				113064			32						
				116823			50						
CR1122-3-02.5 		Purchased	No		160	Each	1.0000		4	32		6/18/10	
RIVET 				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST291			1						
				114348			1						

M118462 (32x)

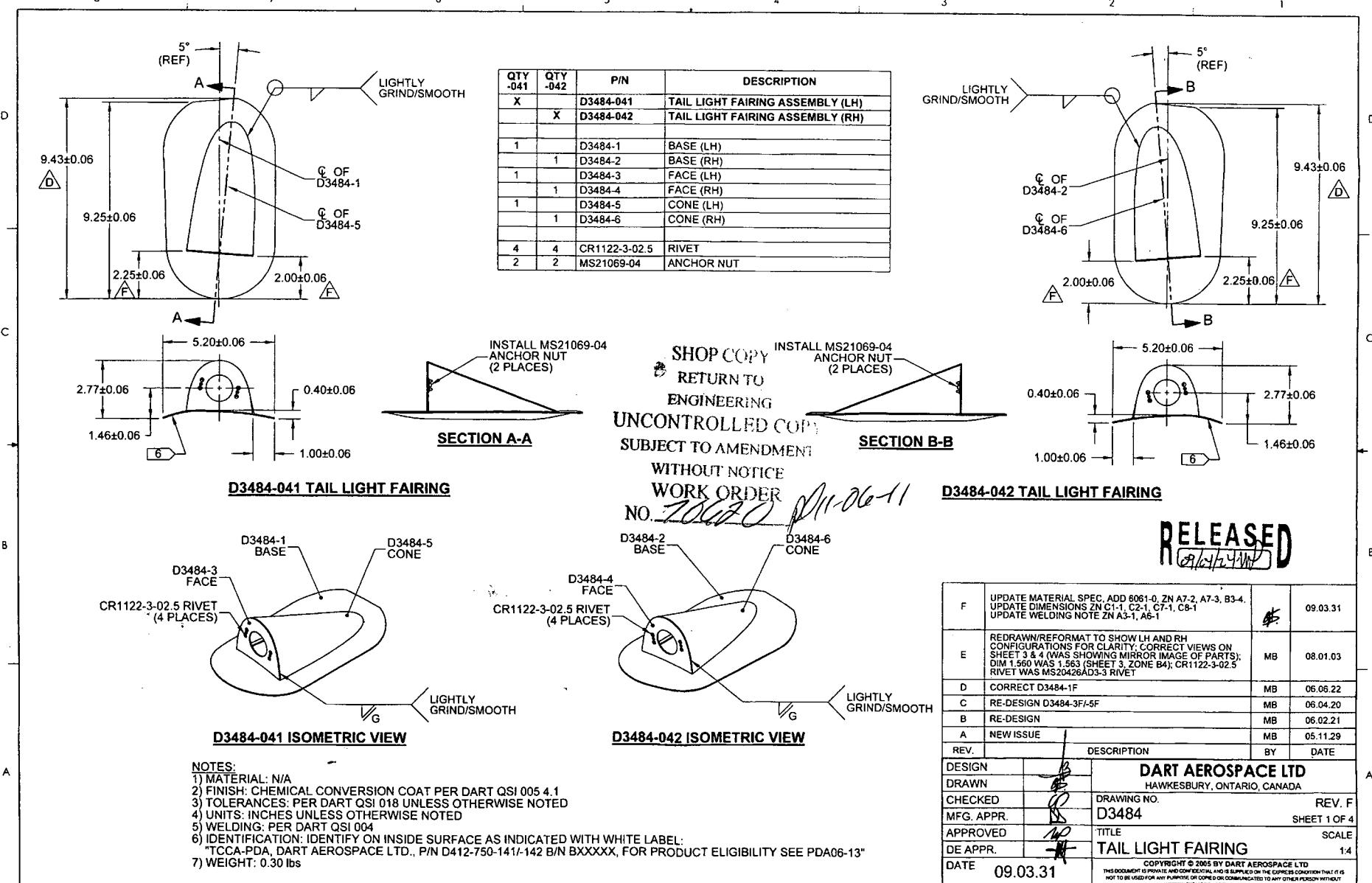
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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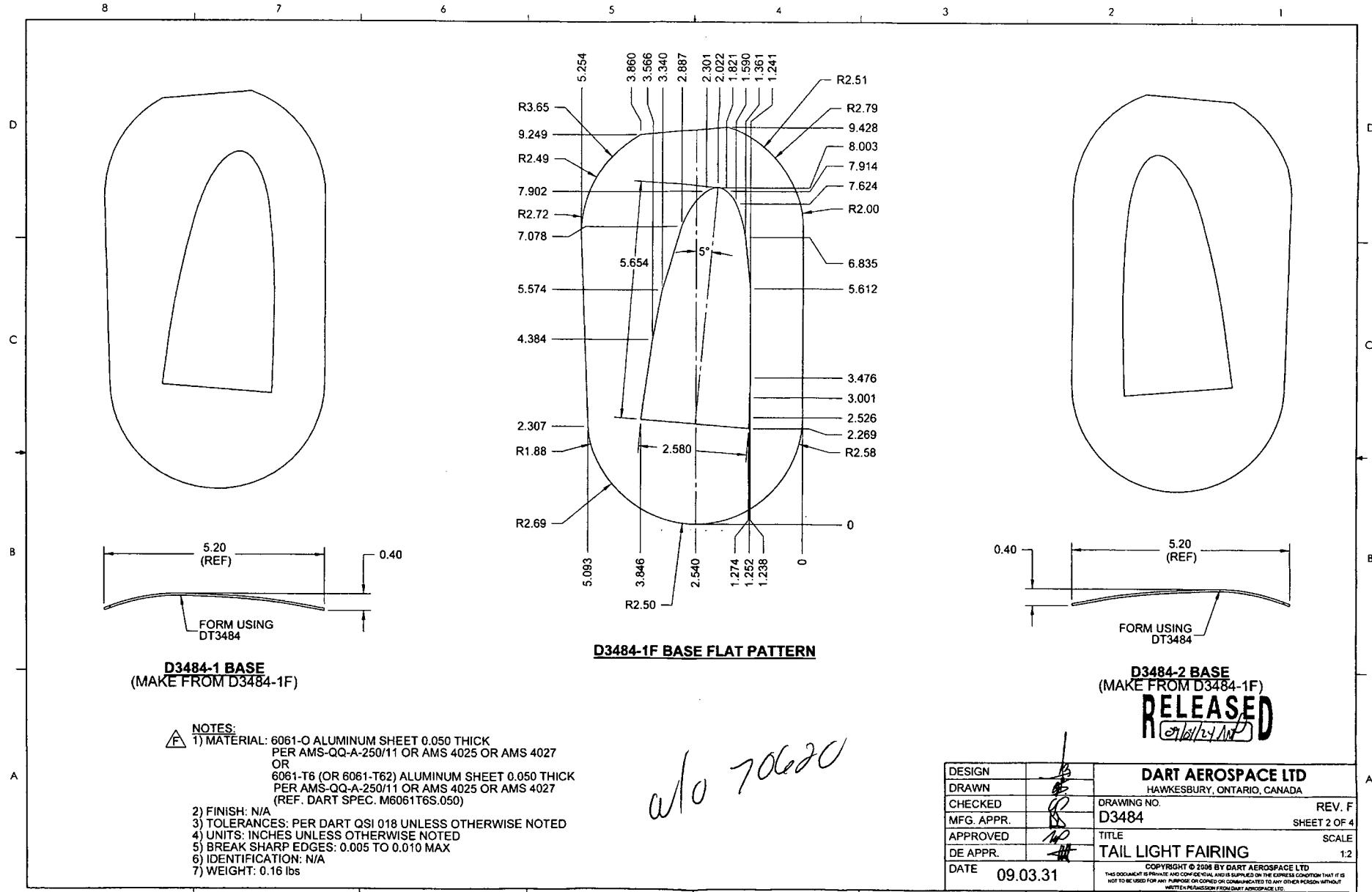
W/O:		WORK ORDER CHANGES					
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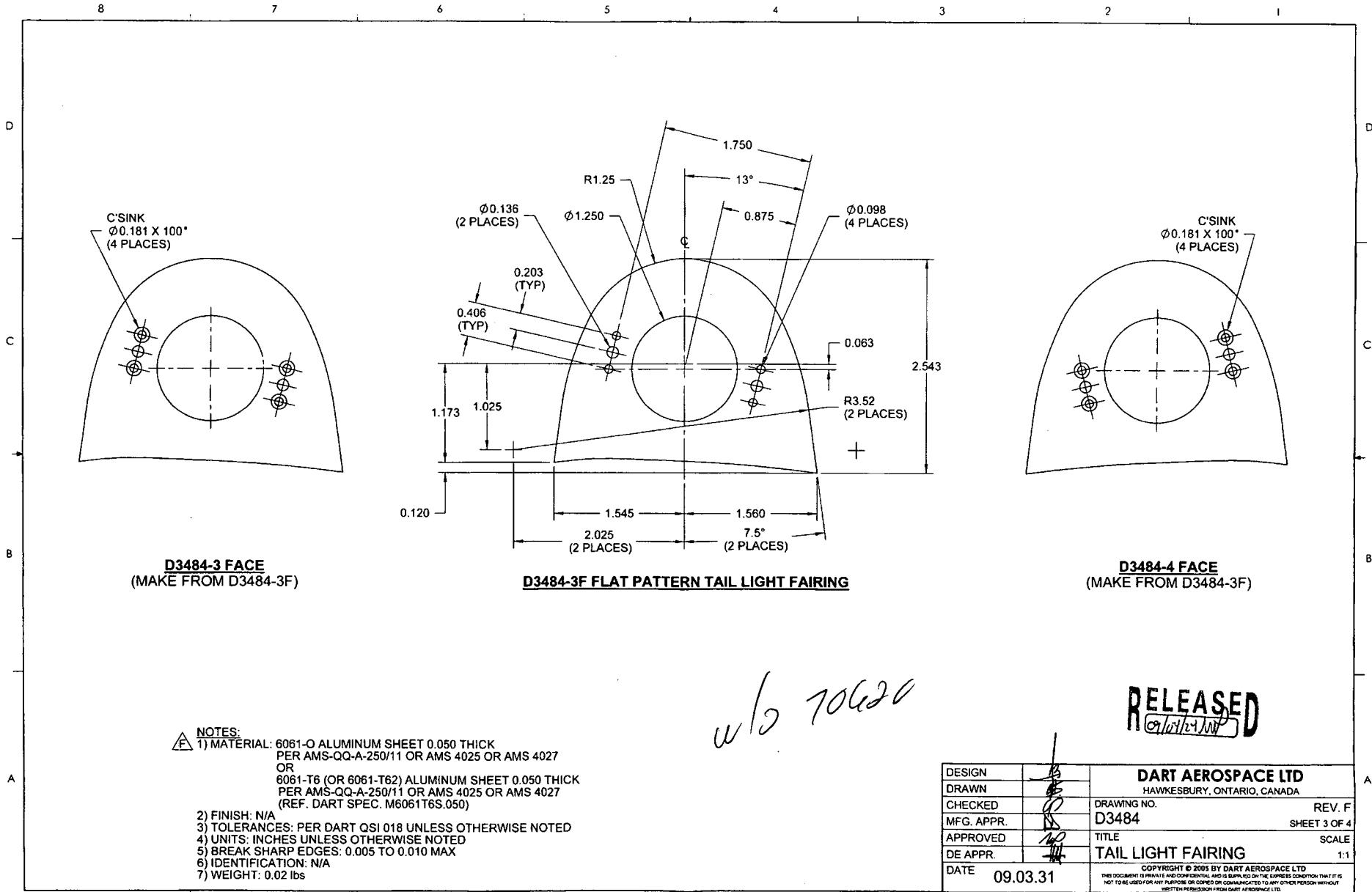


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W/ 70620

DESIGN	<i>BS</i>	DART AEROSPACE LTD	
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>BS</i>	D3484	SHEET 3 OF 4
APPROVED	<i>BS</i>	TITLE	SCALE
DE APPR.	<i>BS</i>	TAIL LIGHT FAIRING	1:1
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EXPRESSED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

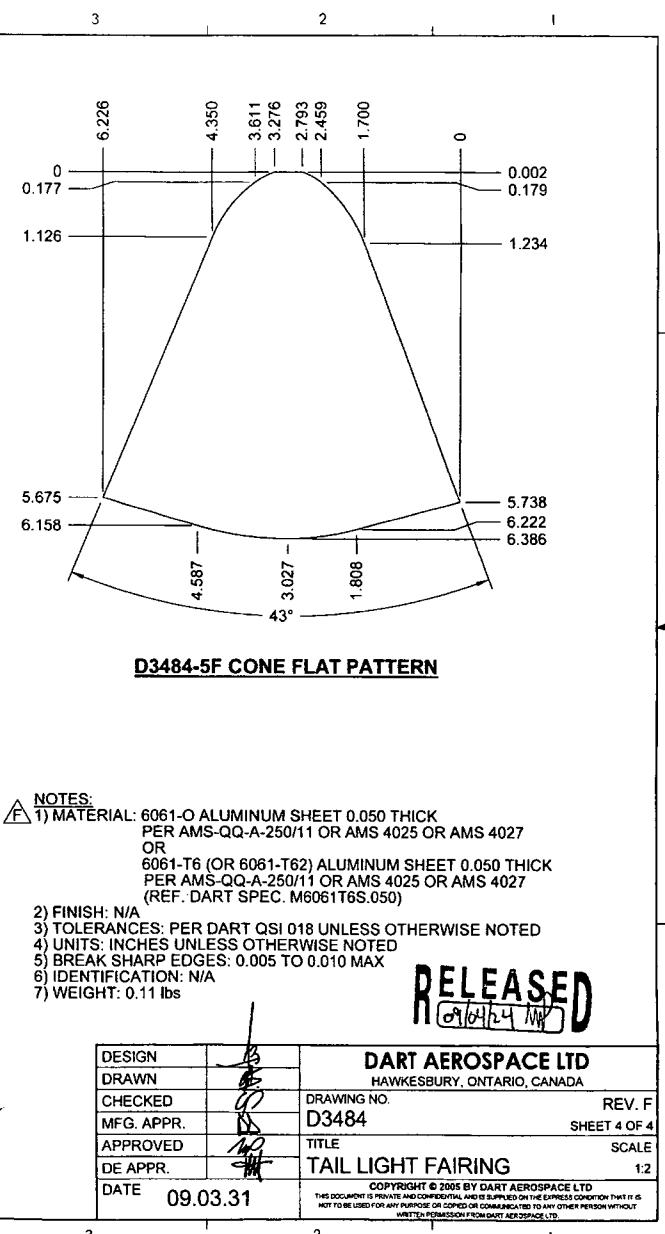
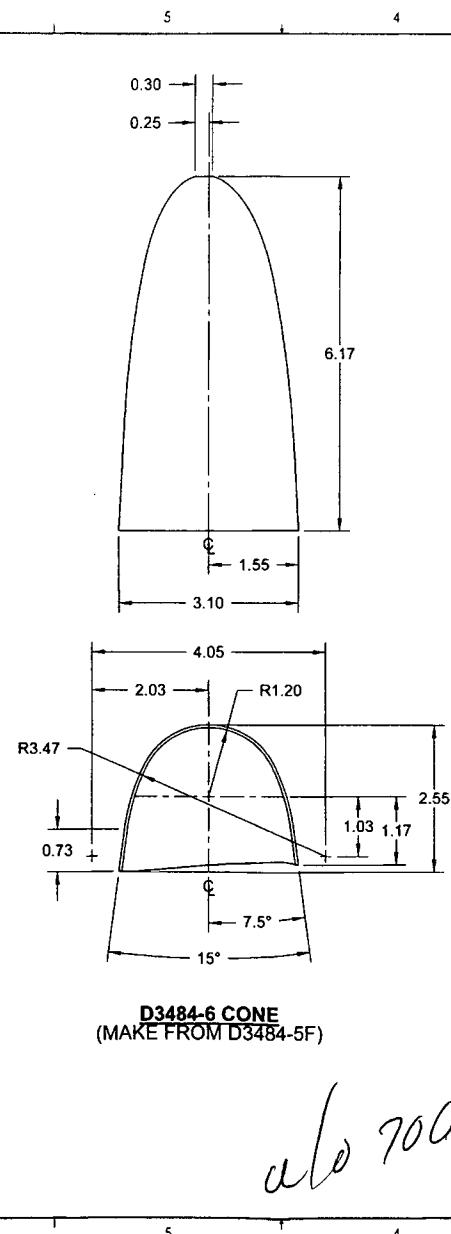
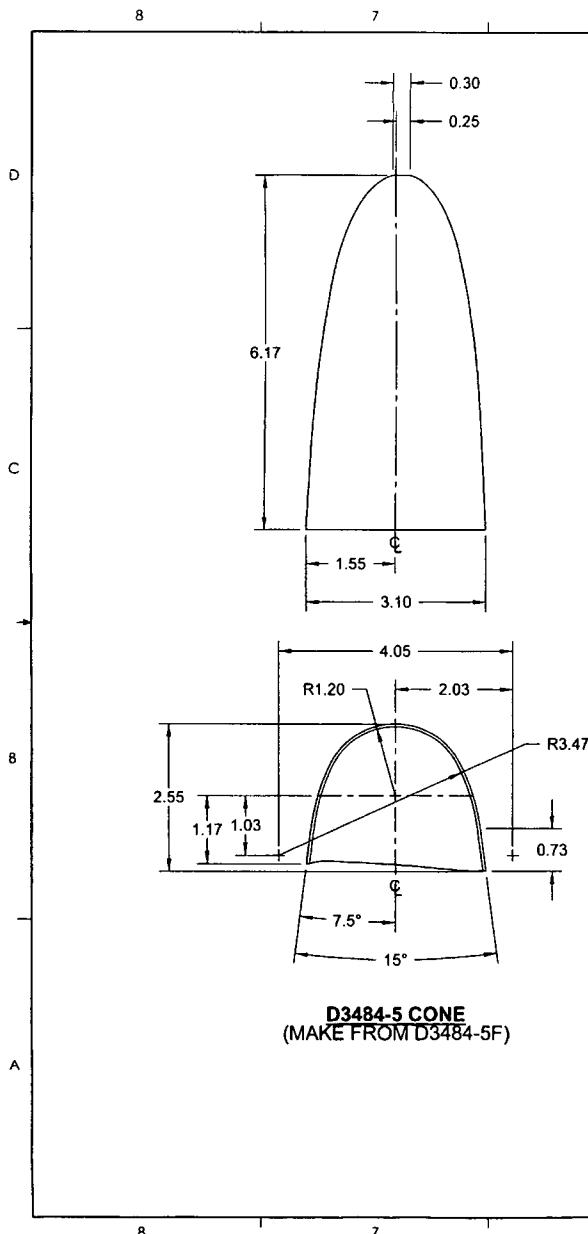
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D3484-5F CONE FLAT PATTERN

NOTES:

F 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.11 lbs.

DELFAS.

RELEASE
09/04/24 MM

DESIGN	<u>B</u>	DART AEROSPACE LTD		
DRAWN	<u>B</u>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>B</u>	DRAWING NO.	REV. 1 OF 1	
MFG. APPR.	<u>B</u>	D3484	SHEET 4 OF 4	
APPROVED	<u>M</u>	TITLE	SCALE	
DE APPR.	<u>M</u>	TAIL LIGHT FAIRING		
DATE	09.03.31	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14274

Purchase Order Date 6/13/2011
PO Print Date 6/15/2011

Page Number 1 of 1

Order From : VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

REVISEd \$ + dates

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3484-041P	Tail light Fairing	7/7/2011 Yes	8.00 Each	FedEx PI collect	\$300.0000	\$2,400.00
2	D3484-042P	Tail Light Fairing	7/7/2011 Yes	✓ 10.00 Each	FedEx PI collect	\$280.0000	\$2,800.00

Special Inst: AS PER DWG D3484 REV. F
B70620
FORMED & WELD AS PER QSI 005
CHEMICAL CONVERSION,
NUTPLATE AND POWDER COAT
TO BE DONE AT DART

Special Inst: AS ABOVE
B70619

PO Total: \$5,200.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 6/15/2011



180 AVENUE LABROSSE
POINTE-CLAIRES, QC, CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE	NR - DYS	MO - MO	AN - YR	N° DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
12	07	11		0465795	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIE PAR SHIP VIA
DART	GFI-0299	0233148	PO14274
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION	
8	D3484041P	TAIL LIGHT FAIRING CERTIFICATE OF CONFORMANCE REQ	

MFG. JOB#J0233148-001 QTY 8

EXPEDITEUR SHIPPER	N° DE BON DE LIVRAISON SHIPPING MEMO NO.



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 4 OUR JOB NO J0233148 SHIPPING MEMO 0465795

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	<u>8 PCS</u>	<u>PO14274</u>	<u>D3484041P</u>	<u>F</u>	<u>TAIL LIGHT FAIRING</u>	<u>F</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T0 (AMS-QQ-A-250/11)</u>		<u>SAMUEL / AMAG ROLLING</u>		<u>62035/01</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0233148-001 (8 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 12 JULY 2011

G.F.I. Q.C. REP.



LES MÉTAUX SPÉCIALISÉS

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTER OF COMPLIANCE - CONFORMITÉ LETTER

Date: MARCH 17th, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0078146 # de commande SSMQ: 090675
Customer's order #: SSMQ's Order #:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Bien à vous,
Yours truly,

Upstream



LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393



Abnahmeprüfzeugnis 3.1 (EN 10204)
Inspection certificate – mill certificate

Zertifiziert nach / certified to ISO 9001, ISO/TB 18948, ENAS 8100, ISO 14001, NADCAP

Nr.: 85344846 01 / 1

Rev. 0

Seite / page: 1 von / of 2

Datum / date: 2010 04 22

Auftraggeber / customer: Samuel Specialty Metals (QC) Div.of Sam. & Fils & Cie (Que.) Ltee. 2225 Av. Francis-Hughes CDN-H7S 1N5 LAVAL, QC	Bestell Nr. / order no.: C62005 Datum / date: 2010 01 14
Warenempfänger / consignee: Samuel Specialty Metals 21525 Clark-Graham CDN-H9X 3T5 BAIE D'URFE QC	Auftragsbest. Nr. / order confirm. no.: 608061 Datum / date: 2010 01 18
Endkunde, Bestell-Nr. / Your cust., ord. no.:	Lieferschein Nr. / delivery note: 85344846 Datum / date: 2010 04 22
	Akkreditiv Nr. / letter of credit no.:

Produkt/product	Bedingungen/terms
Form / form: Sheet Werkstoff / material: 6061 Zustand / temper: O Dim. / dim: [inch]: 0,050x48,00x144,00 Kundenartikel-Nr / customer article no.:	Techn. Lieferbedingungen / techn. spec.: AMS-QQ-A-250/11, 08.1997 ASTM B 209 - 07 AMS 4025L, 07.2008 Cessna CMMP019, Rev. D, 27 March 1991 Cessna CMMP025, Rev. R, 5 July 94 Sondervorschrift / special terms: standard grain

AB-Pos. ord.-Item	BNr/Lot/Teillot Lotto/Pack.	Guss Nr. cast no.	Werkstoff Material	Koflo. packnr.	Gewicht netto weight net	Skt. pos.
06	62035/01/00	01/0038457/0	6061	6080610004	2746,914 lbs	81
06	62035/01/00	01/0038457/0	6061	6080610005	2746,914 lbs	81
06	62035/01/00	01/0038457/0	6061	6080610006	2032,628 lbs	60

D177013
D177014
D177015

Chemische Zusammensetzung / chemical composition (%) Gewichtsanteile / weight proportion											
Guss Nr. / cast no.	AMAG designation										
01/0038457/0	6061	Al	Mg	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Sondere Element
	spec. min.			0,40		0,15		0,80	0,04		
	spec. max.			0,80	0,70	0,40	0,15	1,20	0,35	0,25	0,15
	actual	97,28	0,74	0,42	0,23	0,11	0,89	0,18	0,06	0,06	0,02
		Sondere Elemente									
	spec. min.										
	spec. max.			0,15							
	actual	0,04									



Abnahmeprüfzeugnis 3.1 (EN 10204)
Inspection certificate – mill certificate

Nr.: 85344846 01 / 1

Rev. 0

Seite / page: 2 von / of 2

Datum / date: 2010 04 22

Zertifiziert nach / certified to ISO 9001, ISO/TB 18948, EN/AS 6100, ISO 14001, NADCAP

Zugversuch / Tensile test

BNr/Los Lot/No.	Zustand temper	Richtung direction	Tests		Rm [kgf]	Rp0.2 [kgf]	A2 ⁿ [%]				
				spec.min.			16				
				spec.max.	22,0	12,0					
62035/01	O	LT	7	Min	16,2	8,8	25				
62035/01	O	LT		Max	16,5	9,0	30				
BNr/Los Lot/No.	Zustand temper	Richtung direction	Tests		Rm [kgf]	Rp0.2 [kgf]	A2 ⁿ [%]				
				spec.min.	30,0	14,0	16				
				spec.max.							
62035/01	T42	LT	7	Min	35,2	17,0	20				
62035/01	T42	LT		Max	35,7	17,7	23				
BNr/Los Lot/No.	Zustand temper	Richtung direction	Tests		Rm [kgf]	Rp0.2 [kgf]	A2 ⁿ [%]				
				spec.min.	42,0	35,0	10				
				spec.max.							
62035/01	T62	LT	7	Min	45,3	40,9	10				
62035/01	T62	LT		Max	45,7	41,2	11				

Sonstige Prüfungen / other Tests

Biegeversuch / Transverse bend test: OK.

Maßkontrolle / Dimensional Check: OK.

Oberfläche / Surface Inspection: OK.

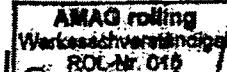
Bemerkungen / notes

Zustand / temper T42+T62: Laborgeglüht / Laboratory temper

Es wird bestätigt, dass die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellung entspricht.
We hereby certify that the material described above has been tested and complies with the terms of the order contract.

Werksachverständiger/ factory specialist	E-Mail / e-mail
Klampfer Josef	josef.klampfer@amag.at

Herstellerland: Österreich / goods origin: The goods are of Austrian origin.
Maschinell erstellt - Gültig ohne Unterschrift / Automated - valid without being signed.



Oliver